

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-017656**Date Inspected:** 30-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yang**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector Mr. M. Manikandan was present during the time noted above for observations relative to the work being performed.

OBG # TRIAL ASSEMBLY YARD (Lift 10E)

This QA inspector witnessed the final bolt tension verification on the Traveler rail brackets of lift 10E. The torque wrench S/N was XO2-666.The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 87 to PP 94:

M20 X 160 – DHGM 200006 – 340 NM

M22 X 120 – DHGM 220053 – 440 NM

For additional information please reference the pictures below:

OBG # TRIAL ASSEMBLY YARD (10AE-10BE)

This QA inspector witnessed the final bolt tension verification on the T-Rib of segment 10AE to segment 10BE. The torque wrench S/N was XO2-666.The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

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PP 88 to PP 89:

M22 X 70 – DHGM 200038 – 480 NM

OBG # TRIAL ASSEMBLY YARD (10BE-10CE)

This QA inspector witnessed the final bolt tension verification on the T-Rib of segment 10BE to segment 10CE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 91 to PP 92:

M22 X 70 – DHGM 200038 – 480 NM

OBG # TRIAL ASSEMBLY YARD (10BE)

This QA inspector witnessed the final bolt tension verification on the road barrier angle of segment 10BE. The torque wrench S/N was XO2-666. The QA inspector witnessed 10% of the bolts on a random basis and found the tensioning of the bolts appeared to be in general compliance with the contract specifications. The panel point and bolt size designations were as follows:

PP 91.5 to PP 92:

M22 X 120 – DHGM 220053 – 440 NM

This QA Inspector randomly observed the following work in progress:

OBG # TRIAL ASSEMBLY YARD (11CW)

The QA inspector observed the welding operation per the FCAW process on weld joint no. 006 in the (2G) horizontal position on longitudinal diaphragm piece mark no. SEG069C. The location was the complete joint penetration groove weld joining the longitudinal Diaphragm flange to floor beam of segment 11CW at work point W4. The welder ID was 040609. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B2-U2-F.

The QA inspector observed the welding operation per the FCAW process on weld joint no. 022 in the (2G) horizontal position on longitudinal diaphragm piece mark no. SEG069C. The location was the complete joint penetration groove weld joining the floor beam stiffener to the longitudinal Diaphragm flange of segment 11CW at work point W4. The welder ID was 040609. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2232-B2-U2-F.

OBG # TRIAL ASSEMBLY YARD (11CW)

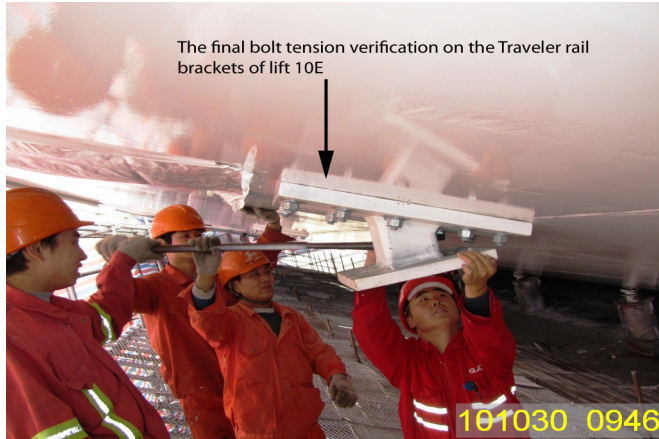
The QA inspector observed the welding operation per the SMAW process on weld joint no. 023 in the (4G) overhead position on counterweight connection plate piece mark no. OBW11A. The location was the complete joint

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penetration groove weld joining counterweight connection plate to edge panel of segment 11CW. The welder ID was 041713. The ZPMC CWI was identified as Li Yang. The welding variables recorded by QC appeared to comply with the WPS-B-P-2214-B-U2-FCM-1.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



Summary of Conversations:

No relevant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Manikandan,Murugan	Quality Assurance Inspector
Reviewed By:	Peterson,Art	QA Reviewer
